

154793

Wednesday, December 21, 2016 2:28:14 PM

N900040100

Setup Start *NS1*

Stop *NS2*

~~***~~

Start Date: 1/3/2017 **Start Qty:** 4.00

Cust Item ID:

Required Date: 1/10/2017 **Req'd Qty:** 4.00

Customer:

Reference:

Approvals: Process Plan: DAS Date: DEC 21 2010

Tooling:

Date:

Run Start *NR1*

QC: 9-89 Date: _____ SPC (Y/N): _____**SPC (Y/N):**

Date:

Stop ***NR2***

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Wednesday, December 21, 2016 2:28:14 PM

154793

Item ID: D4148-041

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Fwd Crosstube Lug Assembly

Start Date: 1/3/2017 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 1/10/2017 **Req'd Qty:** 4.00 ***4***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number**Insp.
Stamp**

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.07

Quality Control

17/02/23 MF 17-2-22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Picklist Print

Wednesday, December 21, 2016 2:28:13 PM

Page 1

Work Order ID: 154793

154793

Parent Item: D4148-041

D4148-041

Parent Item Name: Fwd Crosstube Lug Assembly

Start Date: 1/3/2017

Required Date: 1/10/2017

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC

IPP Rev:B 10.07.22 as per revB DD verf:JLM

10.10.29 as per revC DD verf:EC

AS PER DWG REV.D DD VERF:EC

IPP Rev:C

IPP REV:D 11.03.02

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21043-3		Purchased	No			100	Each	1,392.000	4	8			

MS21043-3

Nut

FEB 15 2017

DAS

6

9-89

Location

Loc Qty

Loc Code

CCK007

400

m135864

400

FG

80

103691

80

FP001

403

m130673

11

m136182

392

GA

39

m133990

39

ST302

401

m135704

1

m136295

400

ST304

69

m131340

69

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
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OTHER : ☐					

Picklist Print

Wednesday, December 21, 2016 2:28:13 PM

Work Order ID: 154793

154793

Parent Item: D4148-041

D4148-041

Parent Item Name: Fwd Crosstube Lug Assembly

Start Date: 1/3/2017

Required Date: 1/10/2017

Start Qty: 4.00

Required Qty: 4.00

MS21043-4

Purchased

No

100

Each

1,376.000

1

12

MS21043-4

Nut

FEB 15 2017

DAS
6
9-80

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

17

m132803

17

OVER007

900

m136192

300

m136263

300

m136406

300

ST302

419

m135600

19

m136148

400

D2690-6

Manufactured

No

100

Each

62.0000

1

4

D2690-6

Lanyard

FEB 15 2017

DAS
6
9-80

Location

Loc Qty

Loc Code

ST009

32

151983

2

152878

30

ST012a

30

154343

30

D3910-1

Manufactured

No

100

Each

33.0000

1

D3910-1

Crosstube Lug

FEB 15 2017

DAS
6
9-80

Location

Loc Qty

Loc Code

ST523

33

152223

5

153293

28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Parent Item: D4148-041

D4148-041

Parent Item Name: Fwd Crosstube Lug Assembly

Start Date: 1/3/2017

Required Date: 1/10/2017

Start Qty: 4.00

Required Qty: 4.00

D4091-1
D4091-1
Mounting Lug

Manufactured No 100 Each 9.0000 1 4
**

FEB 15 2017

DAS
6
9-5

Location Loc Qty Loc Code

ST525 9
151455 9

D4148-1
D4148-1
Crosstube Lug Plate, Fwd

Manufactured No 100 Each 0.0000 2
**

154942 X3
8.10

FEB 15 2017

DAS
6
9-5.0

D4148-3
D4148-3
Stud Receiver, Lower

Manufactured No 100 Each 9.0000 1 4
**

FEB 15 2017

DAS
6
9-89

Location Loc Qty Loc Code

ST086 9
151138 2
153830 7

D4148-5
D4148-5
Eyebolt Stud

Manufactured No 100 Each 2.0000 1 4
**

FEB 15 2017

DAS
6
9-50

Location Loc Qty Loc Code

ST086 2
149684 2

AN3C12A
AN3C12A
Bolt

Purchased No 100 Each 55.0000 2 8
**

FEB 15 2017

DAS
6
9-20

Location Loc Qty Loc Code

GA 37
M128727 9
M133990 28
ST349 18
M136047 18

153813

8

Wednesday, December 21, 2016 2:28:13 PM

Shop Packet Print

DQA: _____ Date: _____



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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause				FAULT CATEGORY																					
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐		Power Loss/Surge ☐	Positioned Wrong ☐																
Design ☐		Operator ☐		Bending ☐		Set-up ☐		Folio/Program ☐	Outside Dimensions ☐																
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐		Grain ☐	Over/Under tolerance ☐																
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐		Weld ☐	Part Incorrect ☐																
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐		Wrong Stock Pulled ☐	Part Lost/Missing ☐																
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐		Out of Sequence ☐	Part Moved ☐																
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐		Off-set ☐	Drawing ☐																
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐		Mislabeled ☐	Finish ☐																
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐		Fit/Function ☐	Misread ☐																
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Misaligned/off center ☐	Turning Sequence ☐																
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____																					
Misidentified ☐		Past Due ☐																							

Picklist Print

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Page 4

Work Order ID: 154793

Parent Item: D4148-041

Parent Item Name: Fwd Crosstube Lug Assembly

154793

D4148-041

Start Date: 1/3/2017

Required Date: 1/10/2017

Start Qty: 4.00

Required Qty: 4.00

AN4C13A Purchased No 100 Each 120.0000 3 12

AN4C13A
BOLT

FEB 15 2017

DAS
6
9-99

Location	Loc Qty	Loc Code
GA	6	
m134754	6	
OVER002	100	
m136263	50	
m136406	50	
ST344	14	
m136192	14	

MS17984-C413 Purchased No 100 Each 35.0000 1 4

MS17984-C413
Quick Release Pin

FEB 15 2017

DAS
6
9-99

Location	Loc Qty	Loc Code
over005	25	
153303	15	
153942	10	
ST315	10	
151622	10	

MS20615-4M18 Purchased No 100 Each 109.0000 8 32

MS20615-4M18
Rivet

FEB 15 2017

DAS
6
9-99

Location	Loc Qty	Loc Code
GA	40	
m134762	40	
ST306	69	
m136182	19	
m136450	50	

136519 x 2

30

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 154793

Parent Item: D4148-041

Parent Item Name: Fwd Crosstube Lug Assembly

154793

D4148-041

Start Date: 1/3/2017

Required Date: 1/10/2017

Start Qty: 4.00

Required Qty: 4.00

NAS1149C0332R

Purchased

No

100

Each

4,421.000

4

16

NAS1149C0332R

WASHER

Location

Loc Qty

Loc Code

FP001

1620

m136301

1620

GA

74

m133284

74

ST260a

2000

m135466

1000

m136042

500

m136444

500

ST266

727

m135408

27

m135766

500

m135908

200

FEB 15 2017

DAS
6
9-89

NAS1149C0432R

Purchased

No

100

Each

1,715.000

6

24

NAS1149C0432R

WASHER

Location

Loc Qty

Loc Code

GA

373

m134676

373

ST260a

1000

m136182

1000

ST266

342

m135979

342

FEB 15 2017

DAS
6
9-89

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Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							